

Date: Thursday, 2/21/2008 9:26:01 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 37562	
Estimate Number : 10267	
P.O. Number :	Part Number : D2438
This Issue : 2/21/2008 S.O. No. :	Drawing Number : D2438 REV. C
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 36508	Material :
Written By :	Due Date : 3/10/2008 Qty: 100 Um: Each
Checked & Approved By : <u>Handwritten Signature</u>	
Comment : Est: E 05.06.28 Bending removed KJ/JLM	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 5767

02/08/02/21

Laser cut as per Dwg D2438

Material release note is required

100

2.0 D2438B Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

CLAMP

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

02/08/18 100

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2438

(6.786" center to center)

02/08/12 100

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble & Deburr any rough edges

02/08/23/28 100

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Thursday, 2/21/2008 9:26:01 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 37562

Part Number: D2438

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/31 (100)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

st456

28/3/31 (100)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08 04.03

Job Completion



mf  
u

08-03-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

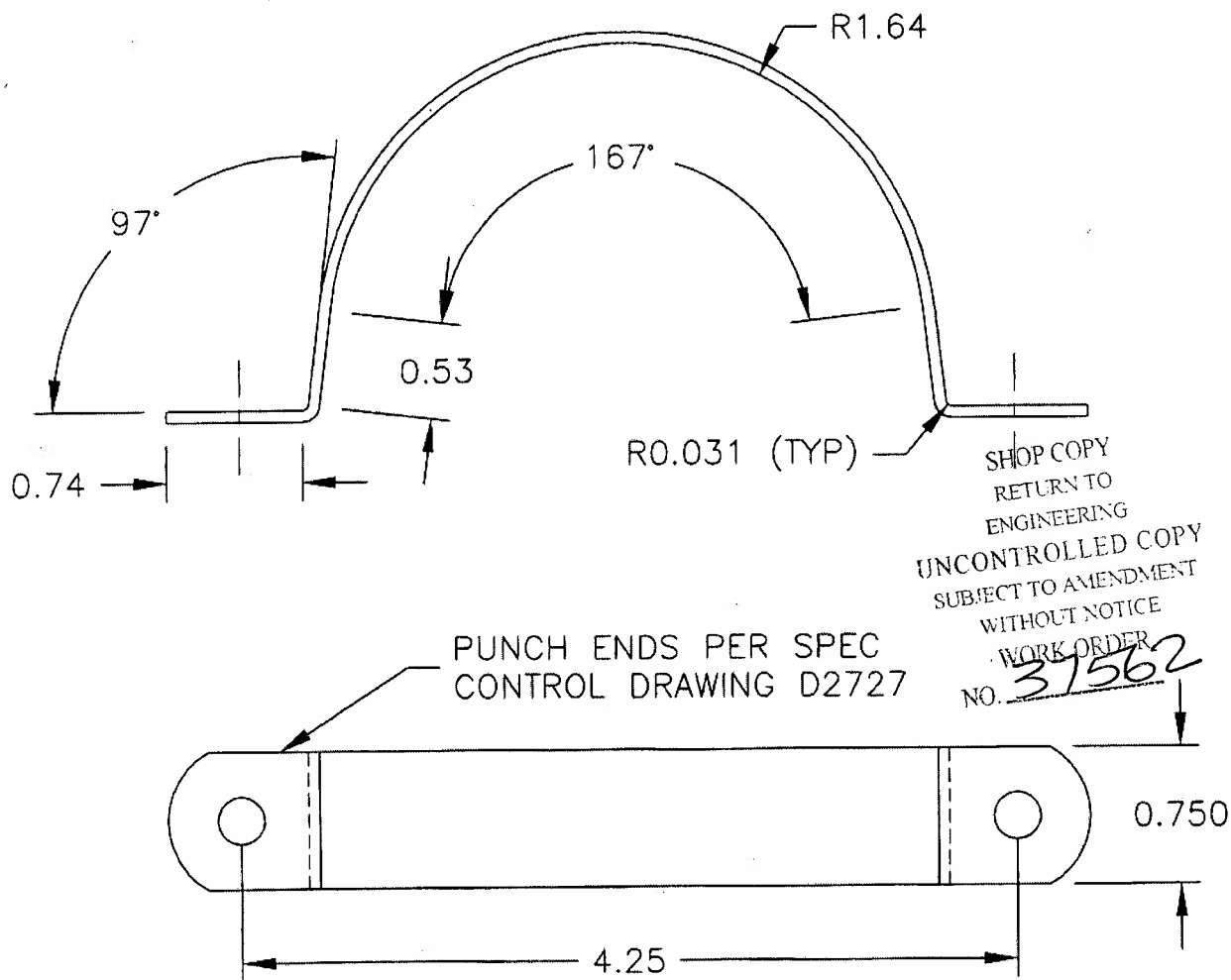
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>MD</i>	APPROVED <i>KE</i>	DRAWING NO. D2438	REV. C SHEET 1 OF 1
DATE 98.05.12		TITLE CLAMP	SCALE 1:1
A	96.01.24	NEW ISSUE	
B	96.05.13	CHANGE LENGTH	
C	98.05.12	R1.64 WAS R1.438, CHANGE GEOMETRY	

RELEASED  
98.06.17 KE



FLAT LENGTH: 7.586 END-END  
6.786 HOLE-HOLE

MATERIAL: AISI 304/316 SS 0.063 THICK  
MINIMUM REQUIREMENT IS ANNEALED CONDITION

# 00.06.06  
CP 00.06.07



180 AVENUE LABROSSE  
POINTE-CLAIRE, QUÉ., CANADA H9R 1A1  
TÉL.: (514) 630-4877 - FAX: (514) 630-4849



# BON DE LIVRAISON - SHIPPING MEMO

DATE DE LIVRAISON  
SHIPPING DATE

N° BON DE LIVRAISON  
SHIPPING MEMO NO.

2008/03/11

0387737

Est une division de Thomas & Betts Fabrication Inc. / GFI is a division of Thomas & Betts Manufacturing Inc.

EXPÉDIÉ À / SOLD TO

EXPÉDIÉ À / SHIPPED TO

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN ST.  
HAWKESBURY, ON, K6A 1K7

CODE DE CLIENT CUSTOMER CODE		N° DE CONTRAT JOB NO.	N° COMMANDE PO NO.	VIA SHIP VIA
DART GFI-0299		J0177650	5767 PO00006767	
QUANTITÉ QUANTITY	VOTRE N° DE PIÈCE YOUR PART NO.	DESCRIPTION		
100	D2438B	CLAMP CUT&FORMED C OF C REQ'D		

TOUTES LES RÉCLAMATIONS DOIVENT ÊTRE FAITES EN DEDANS DE: 5 JOURS DE LA RÉCEPTION  
ALL CLAIMS MUST BE MADE WITHIN 5 DAYS OF RECEIPT OF GOODS.

RECU PAR / RECEIVED BY

# CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



Membre de / A Member of **Thomas & Betts**

180 LABROSSE AVENUE  
POINTE CLAIRE, QC  
H9R 1A1

**DART AEROSPACE LTD**  
1270 ABERDEEN ST.  
HAWKESBURY, ON K6A 1K7

CERTIFICATE NO.	15	OUR JOB NO	J0177650	SHIPPING MEMO	0387737	
ITEM	QUANTITY	PURCHASE ORDER	PART NUMBER	REV	NAME	DWG ISSUE
-	100 PCS	PO00006767	D2438B	C	CLAMP	C
MATERIAL		SUPPLIED BY		MAT. REL. NO.		
S.S.T 304		TW METALS / NORTH AMERICAN		3FW6		

	PROCESS	PROCESSOR	RELEASE NOTE #
1	FIRST ARTICLE INSPECTION REPORT ON FILE	GFI	CONFORMS
2			
3			
4			
5			
6			
7			
8			
9			

WE HEREBY CERTIFY ALL THE PARTS COVERED BY THIS CERTIFICATE HAVE BEEN MANUFACTURED FROM MATERIAL SUPPLIED ON RELEASE NOTE SHOWN ABOVE AND THAT ALL PARTS HAVE BEEN INDIVIDUALLY INSPECTED AND CONFORM TO THE DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

DATE 14 MARCH 2008

G.F.I. Q.C. REP.



PP-1-001 REV 0 Bombardier Certificate of Compliance  
TW Metals District Procedure

Revision: 0

Revision Date: 04-03-00

Superseding: Initial

Page: 1 of 1

CERTIFICATE OF COMPLIANCE

FRAUD AND FALSIFICATION STATEMENT

The recording of false, fictitious, or fraudulent statements or entries on this document may be punished as a felony under federal statutes including federal law, Title 18 chapter 47.

CERTIFICATE OF COMPLIANCE

This certificate of compliance certifies that the material supplied on the purchase order number below complies in all respects with the material description and procurement specifications.

MERCURY FREE STATEMENT

We certify that mercury, radium, or alpha bearing instruments and / or equipment which might cause contamination have not been used in the manufacture, fabrication, assembly or testing of any material supplied by TW Metals Inc. Switches, glass thermometers, standard cell and other items containing the above elements may be used, but they will be located so as not to constitute a contamination hazard.

CUSTOMER NAME GET

PURCHASE ORDER No. 0072971

ITEM No. 0001 SHIPPER INVOICE No. 03231019

MATERIAL: 304 - 5/8 Sheet SPECIFICATION: AISMA 240107

MANUFACTURING MILL: North American Stainless

SIZE: 0625 HEAT / LOT No. 3FW6

PART No. TS06348X964A QUANTITY: 1 EA.

TEST DEPARTMENT CLERK Jarvis Clark

AUTHORITY

Joe Schab  
Director of Quality Assurance



**Penn Stainless Products, Inc.**

TW METALS- CINCINNATI

7840 REINHOLD DRIVE

CINCINNATI, OH 45237-3312

14-Jan-08

655347

M49184686

**CERTIFICATE OF COMPLIANCE**

Description of material:

50 PCS

**SHEET 304 ANN STNLA STL  
16GA POLISH #4 FINISH X 36" X 96"**

**MATERIAL IS #4 POLISH**

RECEIVED  
JAN 21 2008  
*(Signature)*  
ACCEPTED BY

This is to certify that the material furnished on the subject is in accordance to the description and/or specifications

*Penn Stainless Products, Inc.*

*(Signature of Debra M. Kurlowich)*

**DEBRA M. KURLOWICH  
SHIPPING CLERK**

190 KELLY ROAD

P.O. BOX 9001  
(215) 536-3053

QUAKERTOWN, PA 18951-9001  
FAX # (215) 536-3256

**NAS** NORTH AMERICAN  
STAINLESS

# METALLURGICAL TEST REPORT

6870 Highway 42 East  
Ghent, KY 41045-9615  
(502) 347-6000

Certificate: 381003 02

Customer: 0470 002

Mail To:  
PENN STAINLESS PRODUCTS INC.  
P.O. BOX 9001  
190 KELLY ROAD  
QUAKERTOWN, PA 18951-9001

Ship To:  
PENN STAINLESS PRODUCTS INC.  
190 KELLY ROAD  
QUAKERTOWN, PA 18951-9001

Date: 12/26/2007 Page: 1

Steel: 304

Finish: No 4

Your Order: 132221

NAS Order: XN 0386469 01

Corrosion: ASTM A262/22aE, 1B2and-OK

## PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, COLD ROLLED, ANNEALED AND PICKLED, POLISHED  
ASTMA240/07, 480/06b, 666/03, ASTM A240/04-A05, 480/04-A05, BA666/04  
Q0876ED-A X MS PEN, AMS5513E X WRAP IN, MILS059D, AMS3, X CRWN MEAN

## REMARKS:

Mat'l Free of Mercury Contamination. No weld repairs.  
EN 10204 3.1; Q08763F Cond A; RoHS Compliant  
Product mfg. by a quality reg. sys. in conf. w/ISO 9001:2000  
\* Melted & Manufactured in the USA  
NACE MR0 175/2001  
Minimum solution anneal 1900 F., Water Quenched below 800 F

Product ID #	Coil #	Thickness	Width	Weight	Length	Mark	Pieces
023FW6 E	* 023FW6 E	.0595	36.0000	6,110 COIL	834.00	1	1

## CHEMICAL ANALYSIS

Heat	CH	C	CO	CR	CU	MN	MO	N	NI	P	S	SI
3FW6	US	.055	.099	18.528	.495	1.646	.327	.062	8.406	.030	.001	.286

## MECHANICAL PROPERTIES

Product ID #	Coil #	1 d o i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard	A 262 Pr A
023FW6 E	023FW6	PT	100.7	57.11	48.38	90.50	85.50	OK

TEST  
JAN 21 2008  
ACCEPTED BY  
REPORTS

NAS hereby certifies that the analysis on this certification is correct and the material meets the specifications stated.

QC ENGINEER

ERIC HESS

12/25/2007

Certificate of Mill Test Results  
Pg 1/1

/ROSEMARY

PO/Rel M49184686

PENN STAINLESS PRODUCTS, INC.

T W METALS INC  
SHEET 304 ANN STNLS STL  
16GA POLISH #4 FINISH X 36.0000" X 96.0000"LS